



Covinax 404-00 DEV

PRODUCT DESCRIPTION

Covinax 404-00 DEV is a vinyl acrylic copolymer for permanent pressure sensitive applications requiring a balance of moderate peel and tack with high shear strength. It exhibits good tolerance to plasticizer migration from flexible PVC films. **Covinax 404-00 DEV** can be formulated as coater ready for most systems.

PHYSICAL PROPERTIES

Polymer Type: Vinyl acrylic

Protective System: Anionic / Nonionic

Viscosity (cps): 50 – 300 (RVF, Spindle #2/100 RPM /77°F)

Percent Solids: 53% - 56%

pH: 4.5 - 6.0

Freeze/Thaw Stability: Unstable

Weight Per Gallon: 8.6

Borax Compatible: No

Color: White

Shelf Life: Six months

ADDITIONAL INFORMATION

A 1 mil (28g/M²) dry film of **Covinax 404-00 DEV** cast directly onto 1 mil thickness polyester film will exhibit the following average performance properties when tested on #304 stainless steel, which has a #3 surface finish.

Test	Performance Values
180° Peel Adhesion ¹	2.8 pounds
178° Shear Adhesion ²	3000 minutes
Loop Tack ³	2.0 pounds

A 0.8 mil (22g/M²) dry film of **Covinax 404-00 DEV (formulated to coat)** transfer coated to plasticized PVC film will exhibit the following average performance properties when tested on #304 stainless steel, which has a #3 surface finish.

Initial	180° Peel Adhesion ¹	3.1 pounds
	178° Shear Adhesion ²	1300 minutes
	Loop Tack ³	2.1 pounds
Aged @ 140°F	180° Peel Adhesion ¹	4.1 pounds
7 days	178° Shear Adhesion ²	400 minutes
	Loop Tack ³	1.2 pounds

¹Franklin International 03QC5002, 30 minute dwell.

²Franklin International 03QC5003, 0.25 square inch, 1000 gram load, 10 minute dwell.

³Franklin International 03QC5004, 1 square inch contact, 1 second dwell.

IMPORTANT NOTICE TO CUSTOMER:

The recommendations and data contained in this Product Data Sheet for use of this product are based on information Franklin believes to be reliable. They are offered in good faith without guarantee, as conditions and methods for use of our product by Customer and are beyond Franklin's control. Customer must determine the suitability of the product for a particular application before adopting it on a commercial scale.

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Wood Adhesives
Pressure Sensitive Adhesives
Specialty Polymers

Technical Information Sheet 81507

Franklin Adhesives & Polymers Determining Developmental Products' Target Ranges

This Technical Information Sheet reviews how specification ranges are created for new developmental adhesives and polymers (labeled as "DEV") from initial production through commercialization (removal from DEV status).

Franklin utilizes the Stage Gate Process for developing new polymers and adhesive formulations. Customer requirements are entered into the initial stage of the process. During the developmental process, lab and pilot samples are normally created and tested by Franklin technical personnel as well as by the customer for approval. These samples are experimental (EXP) batches and range in quantity from a quart to a 2250 lb. tote.

In order for the EXP product to move to Franklin production, three replicated lab and/or pilot batches are made. From these batches, target ranges are calculated using 3 Sigma limits and are incorporated into Franklin's QC and Production System, creating a DEV product.

Once eight consecutive production batches are made without changes to the formulation or process, the product specifications are set based on these batches, the product is no longer developmental and the DEV designation is removed.

In most cases, target ranges will change from initial production batches through the commercialization process. Often this results in a broadening of the specification ranges. The customer is notified of these changes.

DGP 8/21/09